

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000118**Date Inspected:** 15-Jan-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification** **Fracture Critical**
Mechanical Testing, describe:**Index Lot #:** B41-004-07a**Witness Lot #:** B31-006-07**Bridge No:** 34-0006**Component:** Bid 52, 55 Tower and Girder**Welder:** Zhang Xing Jin**ID #:** N/A**Joint Description:** B-U2a-GF (mod)**WPS ID #:** PWPS-B-T-3233-1 **N/A****Base Metal:** A709-HPS-485W**PQR ID #:** HP2006131 **N/A****Thickness:** 75mm**Process:** FCAW **N/A****Electrode Spec/Class:** A5.20/E71T-1**Positions:** 3G **N/A****Backing Material:** A709-HPS-485W**CWI:** Liu Liu **N/A****Average Amps:****AWS Code:** D1.5-2002 **N/A****Average Volts:****Applicable Sec:** 5.12.1 **N/A****Travel Speed:****Heat Input:** **N/A****Preheat:****N/A****Summary of Items Observed:**

On this date the QA representative Joe Lanz performed a review of radiographic film of a procedure qualification test plate ID HP2006131, Caltrans index lot number B41-004-07 performed by Zhenhua Port Machinery Company (ZPMC). The test plate was radiographed by Jin Tong Jian Chen NDT Company LTD. of Shanghai China. The NDT Level II Inspector Mr. Huang Ming Hai performed the radiography and review of the radiographic film prior to submitting the NDT report and the radiographic film to the Quality Assurance Inspector for review. The film quality and weld quality were interpreted by Mr. Hai for compliance with AWS D1.5-2002 Section 6 Part B and Figure 6.1A and the results met the requirements of paragraph 6.26.2. Mr. Hai found the radiographs to be acceptable and the QA inspector concurred with the interpretation with the following exception. The view number 2 was found to have no location markers visible on the film. AWS D1.5-2002, paragraph 6.10.8 states "Welded joints shall be radiographed and the film indexed by methods that will provide complete and continuous inspection of the joint within the limits specified to be examined." Caltrans witness lot number B31-006-07 was assigned for tracking purposes.

Summary of Conversations:

The issue noted above was brought to the attention of the Senior area lead QA inspector David McClary. The QA inspector noted that the Engineer may want to accept the film with the deficiencies noted above based on the

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ability to interpret the weld quality in the films.

Observed welding,testing or results: is in general conformance with the contract requirements.
 is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
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Reviewed By:	Wright,Mark	QA Reviewer
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